

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2016-154** Date Opened: **09 November 2016** Title: **Fabrication**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350/355** Product Type: **Cargo Basket & Lid** Product Model: **XL** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
 Additional Work Sheets (Standard Practice)
 Drawings (See List Below)
 Parts Distribution Sheet
 Sub Component Tags
 Completed Certification
 Time Sheet (R&D)
 Notes

Initial or N/A

DM
N/A
DM
DM
N/A
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
 Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	DM
94012	1	Lid	DM
70405	4	Lid Walkway	DM
84262	2	Basket Handle Prov.	DM
84263	0	Lid Handle Provisions	DM
94023	1	Attachment Hoop	DM
94030	1	Hoop	DM
70406	3	Front End Cutout	DM

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
 Quantity Incomplete on This Work Order
 Further Processing Required Before Release
 Release to Stock as Components

As Instructed

1 / 1
N/A
N/A
N/A

Certification

Form One Completed
 Serviceable (Green) Tag Completed
 In Process (Yellow) Tag Completed
 Unserviceable (Red) Tag Completed
 Parts Tracking (White) Tag Completed
 Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
N/A
JC

Additional Documentation

Documentation of a minor change
 Non-Conformance Report Required
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
 Research and Development
 Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: **D. Bartfai**Sign: SCA: **AD07**Date: **12-Dec-16**

ICC / Dual Inspection performed by:

Print: **J. Clarke**Sign: SCA: **AD02**Date: **15-Dec-16**

Work Order closed by:

Print: **J. Clarke**Sign: SCA: **AD02**Date: **20-Jan-17**

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

CARGO BASKET HOOP FABRICATION - 94023

General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Work Order: 2016-154

Date Open: Nov 2016

Complete (initial or SCA #)	
AD 73-04 07	AD 73-04 07

1. ½ Hoop Fabrication – ½" hoop

- Cut ½" x 0.035 material to 23.0", square ends.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
 - Upper tube stop: ??"
 - Lower bend stop: 12mm
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- Check for:
 - hoop height: 18" (Outside to outside)
 - adjust upper stop for height if required

AD 73-04 07	AD 73-04 07
-------------------	-------------------

2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

- Start with ½" half hoop from step 1.
- Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - locate 0.23" from edge (within tolerance specified on drawing).
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

AD
73-04
07Complete
(initial or SCA #)AD
73-04
07

3. ½ Hoop Fabrication – 1" hoop

- Cut 1" x 0.065 material to 33.25", on end 60 degrees, one end @ 16 degrees. 33.25" distance is short edge of 16 deg to long edge of 60 deg.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- Mark tube at ~~25 3/4"~~ ^{25 11/16"} from long edge of 16 degree end.
- Set lower stop to 101 degrees
- Slide stock tube through bending die up to mark. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains at mark.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
 - hoop height from jig
 - adjust mark for height if required
 - bottom length
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

AD
73-04
07AD
73-04
07

4. ½ Hoop Machining – 1" hoop

- Start with 1" ½ hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

AD
73-04
07AD
73-04
07

5. Joint Preparation

- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

AD
73-04
05

Next

AD
73-04
05

Page

6. Welding – Lugs

CARGO BASKET HOOP FABRICATION - 94023

Complete
(initial or SCA #)

- a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- c. Record lug and welding rod PO/WO on attached material list.

AD
73-04
05

AD
73-04
05

7. Welding – Handle Bushings – 84262-01

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

AD
73-04
05

AD
73-04
05

8. Welding – Hoop Assembly

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

AD
73-04
07

AD
73-04
07

9. Finishing and Inspection

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2016-154Date Opened: Nov 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Hoops Fabrication

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
	2		94023-01	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16037
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 1		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	2015-108
	. 1		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	2015-108
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	2016-134
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	. A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	

SKI

AS350 Quick Release Cargo Basket Hoop

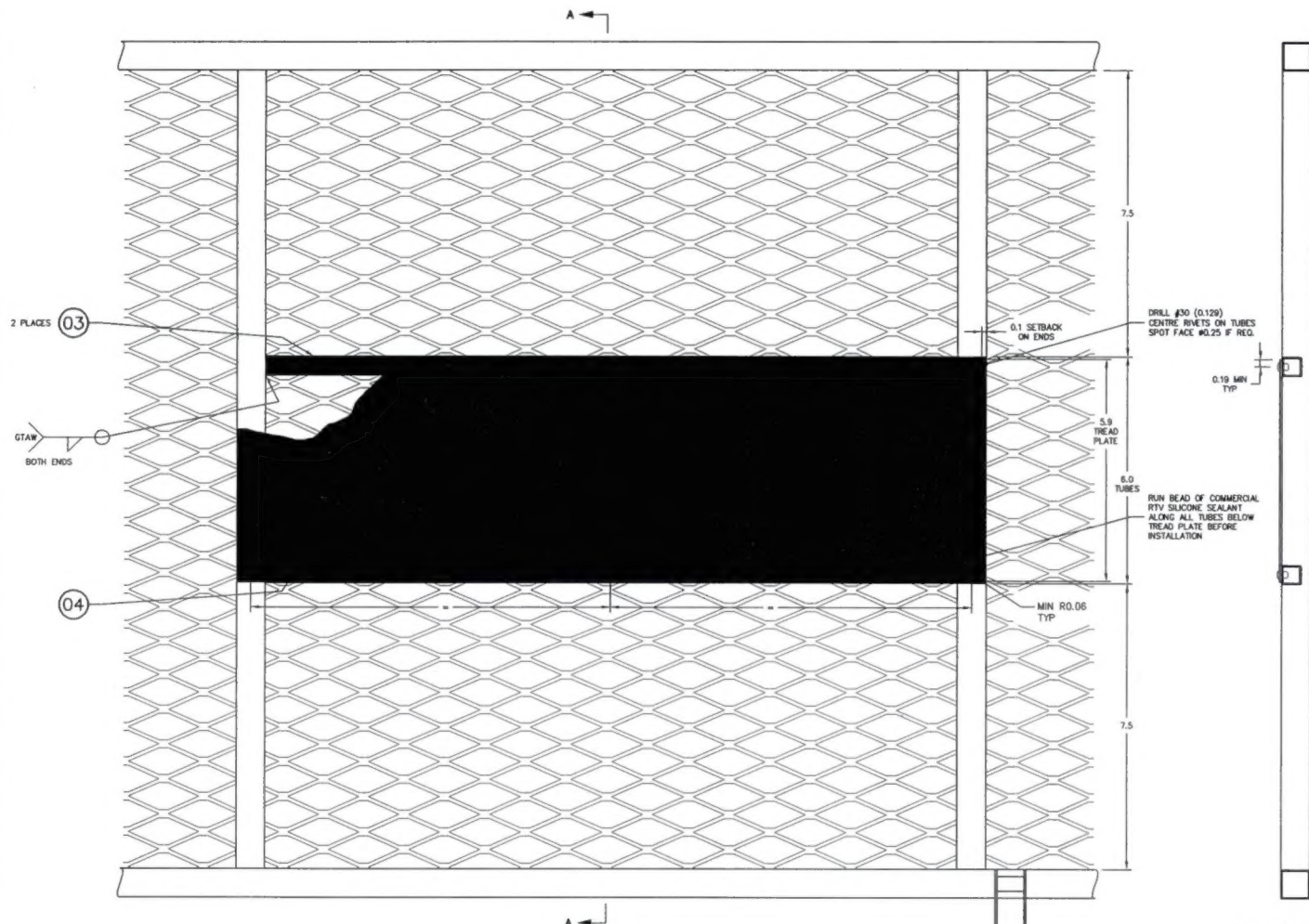
Requirements
*Review LOED to ensure most up to date specifications.
*Cut 52 7/8
*Cut one end at 90 degrees and the other at 16 degrees.
*At the 90 degree end measure 13 3/8 and mark. Bend at that mark.
* At the longest part of the 16 degree end measure 15 3/16 and mark. Bend at that mark.

LOWER STOP 103 FOR 90

85 FOR 16

(CONFIRMED)

2016-154



(01) BASKET LID ASSEMBLY

SECTION A-A

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCCONNELL DOUGLAS MD600, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

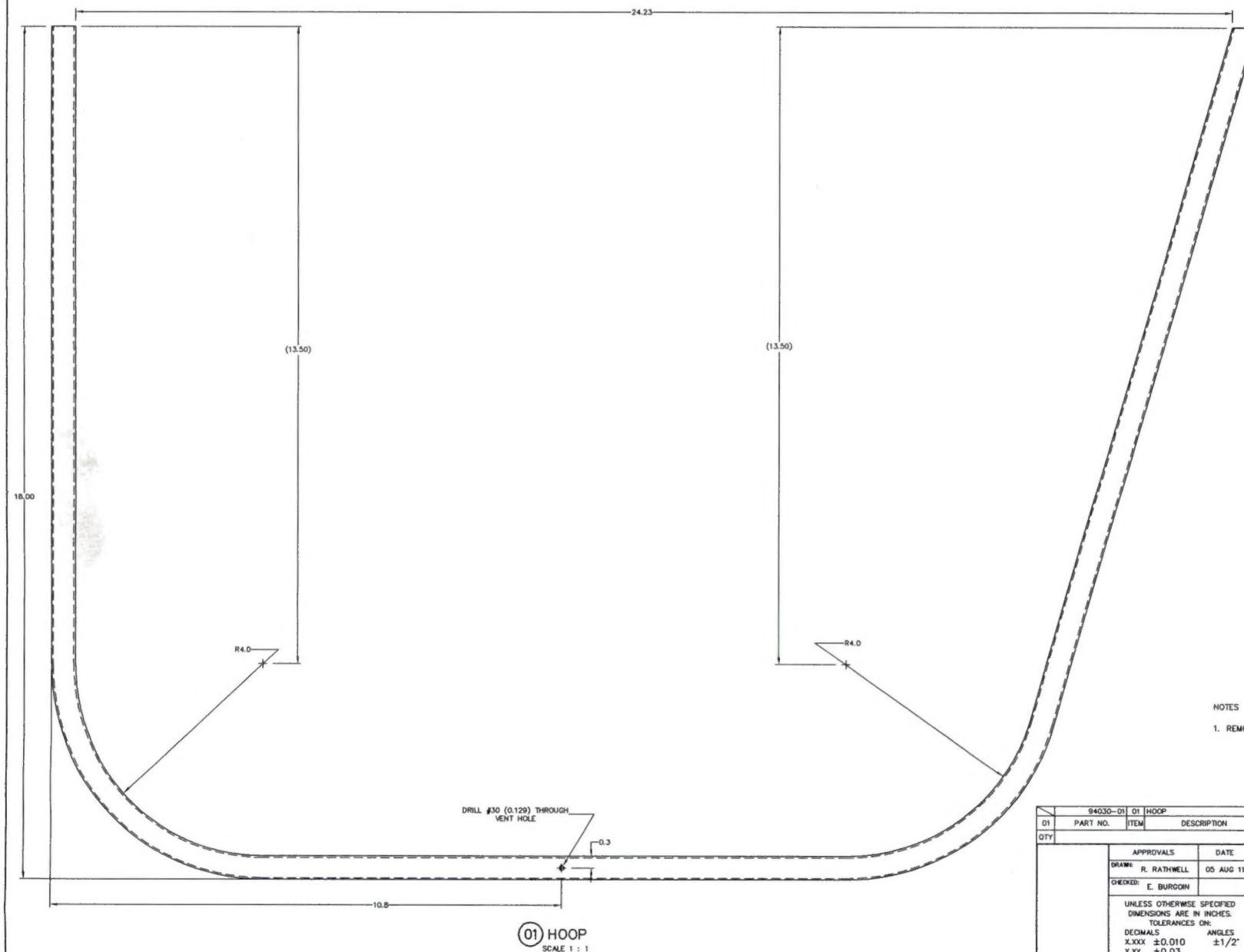
A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						

BASIC CODE REF. HAS 523		DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	APPROVALS		DATE
C=COUNTERSUNK D=DIMPLE		DASH NO. FOR LENGTH	DRAWN: JEFF CLARKE		21 SEPT 2008
DIGIT=# OF SHEETS TO BE DIMPLED			CHECKED: E. BURCON		
BASIC CODES: BJ=MS20470AD BB=MS20426AD AR=CR3213 AP=CR3212			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
			DECIMALS		ANGLES
			X.XX ±0.010		±1/2°
			X.XX ±0.03		
			X.X ±0.1		
			INSTALL NEW RIVET		
			REMOVE/REPLACE RIVET		
			EXISTING RIVET		
			LIST OF MATERIALS		
			AERO DESIGN LTD.		
			9888A MALASPRA ROAD		
			POWELL RIVER, BC, CANADA, V0A 0G3		
			TEL: 804.483.2278		
			www.aerodesign.ca		
			CARGO BASKET		
			LID STEP MODIFICATION		
			SCALE 1 : 1.5	DWG. SIZE	DWG. NO.
			SHEET 1 OF 1	A1	70405
					4

2016-154


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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAWING REFORMATTED TO A1	BUC	11/07/2014



NOTES

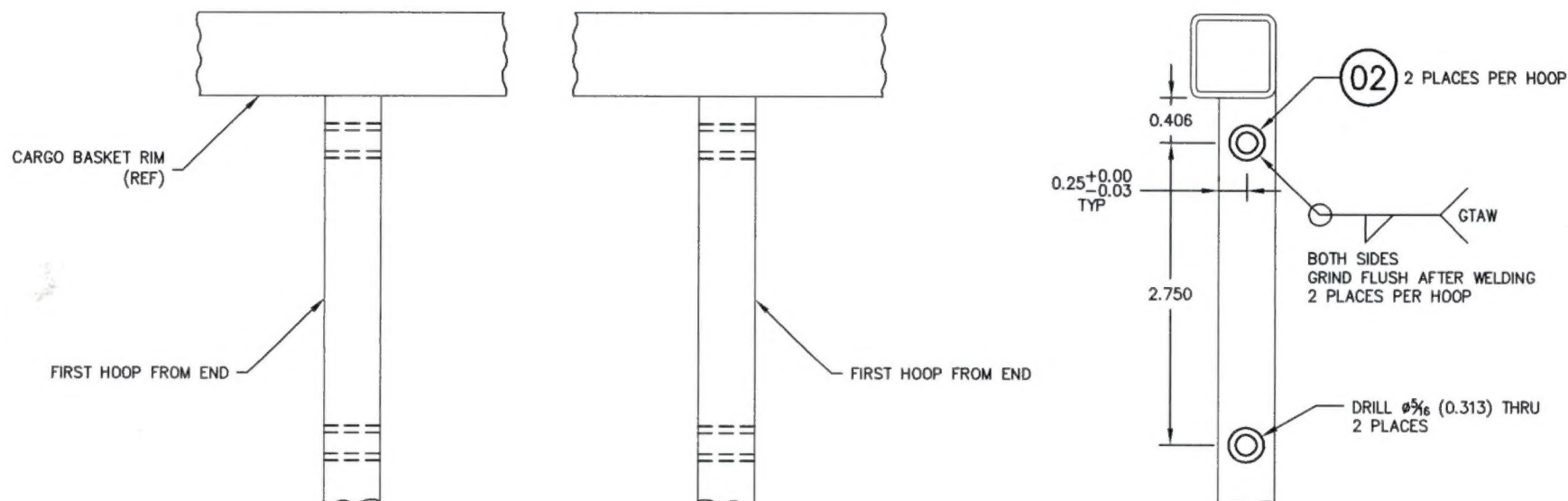
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

94030-01 01 HOOP		4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SDR TUBE		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY						
LIST OF MATERIALS						
APPROVALS		DATE		 AERO DESIGN LTD. 6888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 604.483.8376 www.aerodesign.ca		
DRAWN: R. RATHWELL		05 AUG 11				
CHECKED: E. BURCOIN						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1						
SCALE 1:1		DWG. SIZE		DWG. NO.		REV.
SHEET 1 OF 1		A1		94030		1

2016-154

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014



01 BASKET HANDLE PROVISIONS ASSEMBLY PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY
01	PART NO.	ITEM	DESCRIPTION
QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



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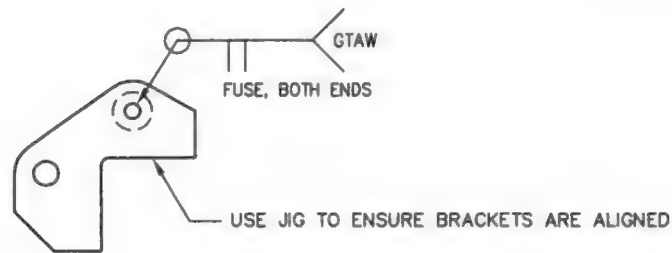
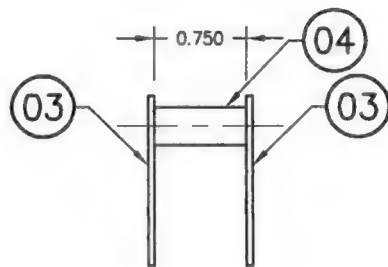
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.8376 www.aerodesign.ca

HELICOPTER CARGO BASKET
BASKET HANDLE PROVISIONS ASSEMBLY

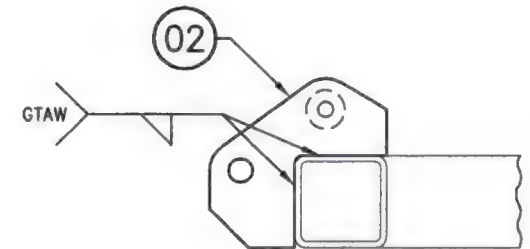
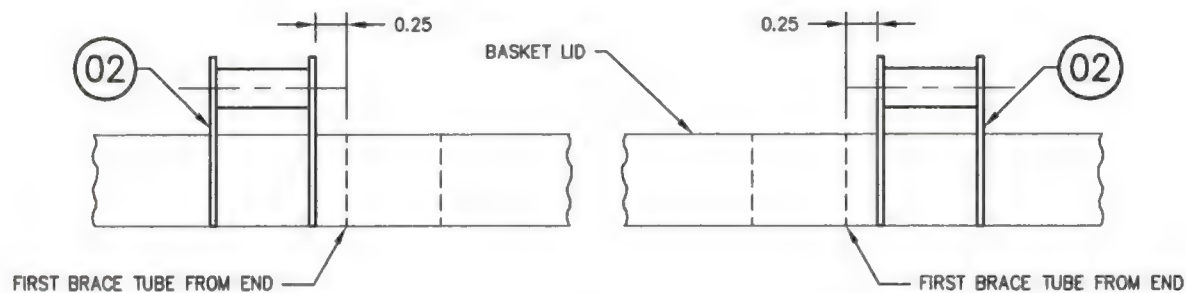
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



02 HANDLE BRACKET ASSEMBLY



01 LID HANDLE PROVISIONS ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
	2	84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



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TEL: 604.458.2376 www.aerodesign.ca

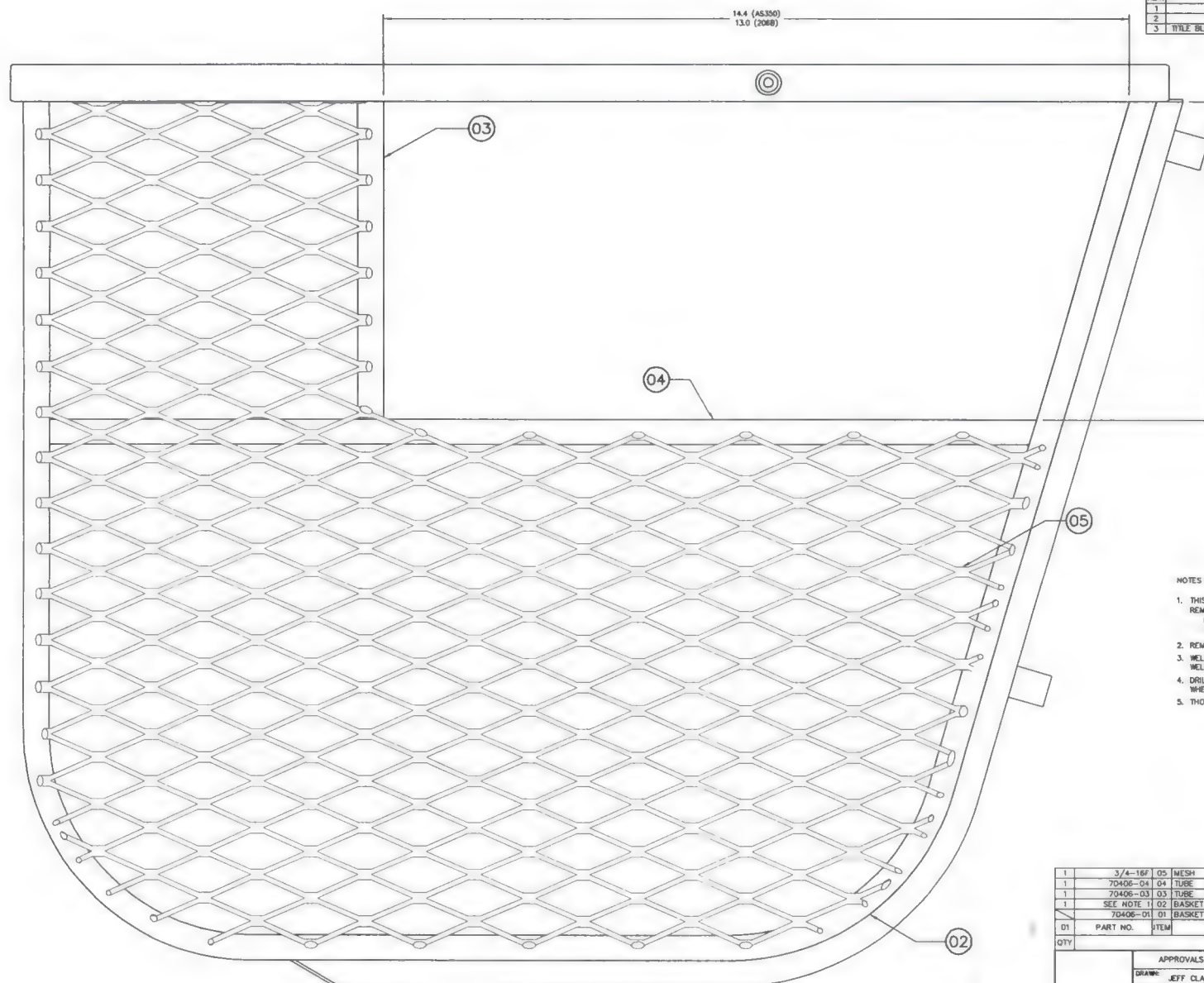
HELICOPTER CARGO BASKET
LID HANDLE PROVISIONS ASSEMBLY

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84263	0
SHEET 1 OF 1			

2016-154

R/H cut out with cover

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD HELL 2008B	BJC	DEC 22/08
2	MODIFY OPENING	BJC	OCT 27/11
3	TYPE BLOCK UPDATED; LONG/EXTRA LARGE CONFIGURATION ADDED TO SHIT. 2	BJC	14/07/2014



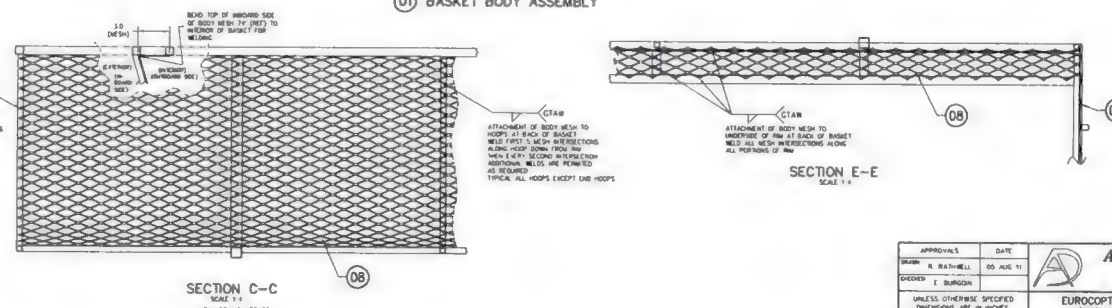
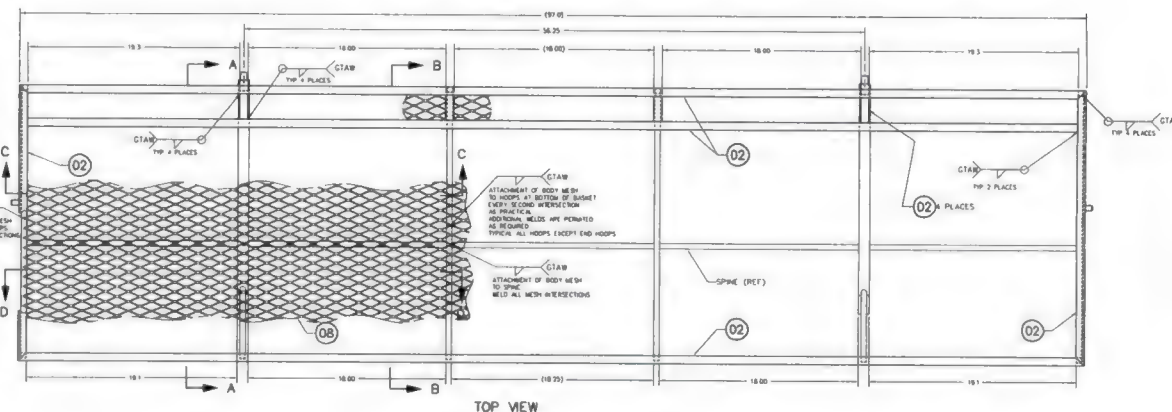
NOTES

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY. REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH THE FOLLOWING DRAWING:
EUROCOPTER AS350/AS355: 78411 (LONG) OR 94011 (EXTRA LARGE)
HELL 2008B: 81111 (LONG)
2. REMOVE ALL BURRS AND BREAK SHARP EDGES
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
4. DRILL #30 (0.125) HOLES TO VENT TUBES INTO BASKET HOOP AND/OR RIM. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

1	3/4-16F 05	ISH	MILD STEEL	COMMERCIAL		
1	70406-04 04	TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE	
1	70406-03 03	TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET BODY ASSEMBLY				
1	70406-01 01	BASKET BODY ASSEMBLY - MODIFIED FORWARD END				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
APPROVALS			DATE		<div><div>AERO DESIGN LTD. 8088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 866.482.5976 www.aerodesign.ca</div></div>	
DRAWN: JEFF CLARKE			19 MAR 2008			
CHECKED: E. BURGOIN						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES OR:			QUICK RELEASE CARGO BASKET OPEN FORWARD END MODIFICATION			
DECIMALS			ANGLES		SCALE 1:1	
X.XXX ±0.010			±1/2°		DWG. NO.	
X.XX ±0.03					REV.	
X.X ±0.1					SHEET 2 OF 2	
					A1 70406 3	

01 BASKET BODY ASSEMBLY
EUROCOPTER AS350 LONG SHOWN
EUROCOPTER AS350 EXTRA-LARGE SIMILAR

R/H with cut out and cover



SECTION E-E
SCALE 1/4"

- NOTES
- 1 REMOVE ALL BLUES AND BREAK SHARP EDGES
 - 2 PRIOR TO WELDING, DRILL AND REAM HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, ALL EXPOSED HEAT HOLES WITH ROSETTE WELD
 - 3 WELDING OF 430 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D6.60
 - 4 430 AND 1018 STEEL WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
 - 5 430 STEEL AND 430 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
- INSTALL ITEM 7 (BASSET HANDLE PROVISIONS) ASSEMBLY IN ACCORDANCE WITH HERO DESIGN L8
- DRAWING 42462 BEFORE WELDING HOOPS TO RUN
- 6 FINISH THOROUGHLY CLEAN AND POWDER COAT BASSET ASSEMBLY

[illegible]

APPROVALS		DATE		 AERO DESIGN LTD. 8088 MALASPINA ROAD POVELL, FERRY BE CANADA, V8A 0C3 TEL: 250-696-0976 www.aerodesign.ca	
DRAWN BY	R. BATHWELL	05 JUL 2011			
DESIGNED BY	J. BURTON				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON					
DECIMALS	IN		ANGLES		
1/16	0.010		1/2°		
1/32	0.003				
1/64	0.001				
SCALE 1 OF 3 SHEET 1 OF 3				PART NO A0 94011 1	
EUROCOPTER AS350 & AS350S SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY (EXTRA LARGE)					



2016-154

Nov 2016

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket



Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway



70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2016-154

Date Open: Nov 2016

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

AD
73-04
05

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD
73-04
05

3. Inspection

- a. Rim for complete welds

AD
73-04
05

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD
73-04
05

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD
73-04
05

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AD
73-04
05

7. Inspection

- a. Frame assembly for complete welds.

AD
73-04
05

CARGO BASKET LID FABRICATION

Complete
(initial or S.O.#)

AD
73-04
07

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

AD
73-04
06

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

AD
73-04
06

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

AD
73-04
07

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

AD
73-04
02

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

AD
73-04
02

WO# 2016-154

R/H with cut out

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket ← *

Options 70406, Revision 2 – Front end cutout – 764/776/784/940 ← *

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2016-154

Date Open: Nov 2016

AD
73-04
05

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD
73-04
05

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD
73-04
05

3. Inspection

- a. Rim for complete welds

AD
73-04
05

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

AD
73-04
05

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD
73-04
05

6. Inspection

- a. Frame assembly for complete welds.

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD
73-04
07

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AD
73-04
05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

AD
73-04
05

9. Weld basket components
 - a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
 - b. TIG weld caps to close top of 1" hoops as applicable.
 - c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
 - d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD
73-04
07

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD
73-04
02

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SDA #)

73-04
02

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2016-154Date Opened: Nov 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	94011	94011-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14009</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		94023-01	Hoop - attachment		
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
Step 4.g.		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	<u>16009</u>
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	<u>16038</u>

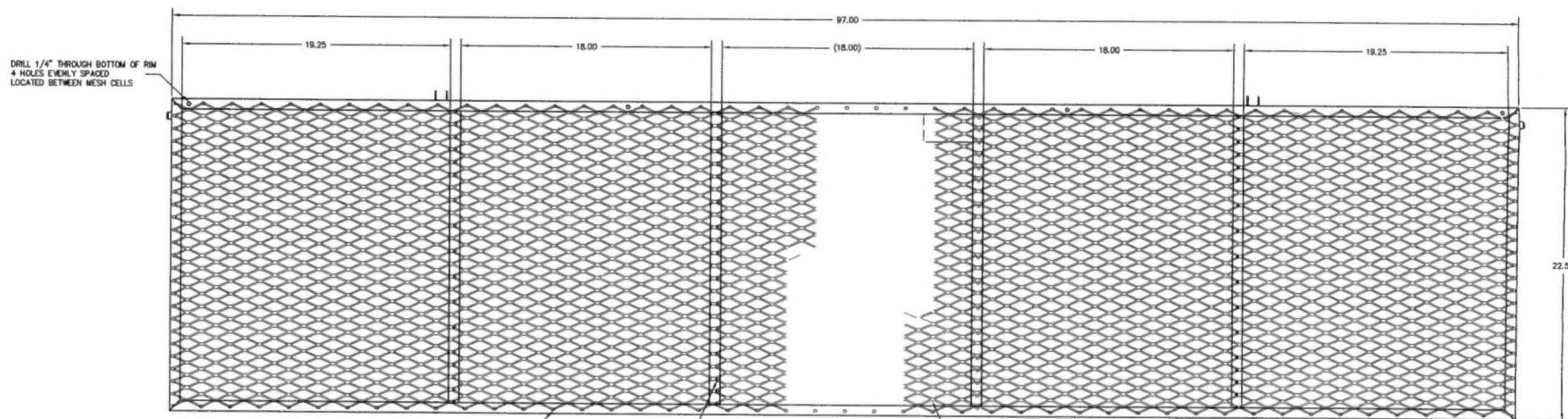
Work Order: 2016-154Date Opened: Nov 2016Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mesh</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	15090
Step 9				<i>Weld Basket Components</i>		
	2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 10				<i>Clean Up</i>	None	
Step 11				<i>Inspection - Final Assembly</i>	None	
Step 12				Powder Coating		16081

2016-154

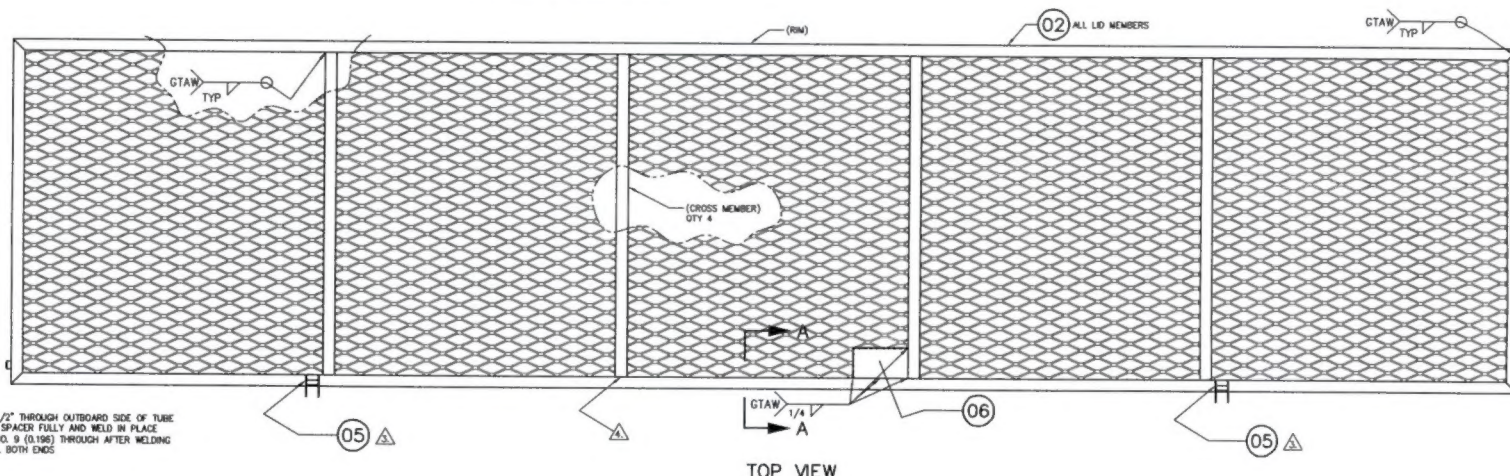
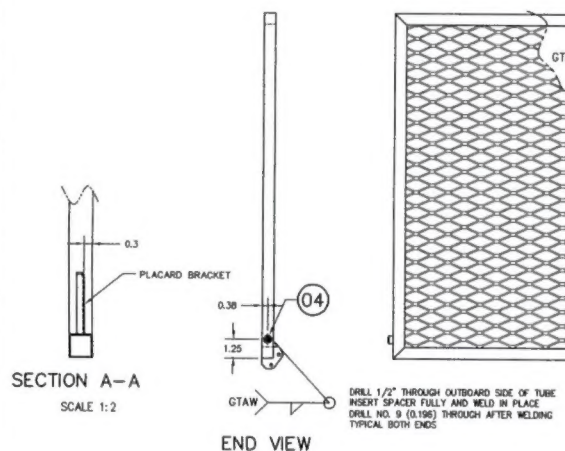
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 36273-01 TO 84263-01; ITEM #'S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



GTAW TYP
ATTACHMENT OF MESH TO RIM
WELD EACH INTERSECTION

GTAW TYP
ATTACHMENT OF MESH TO CROSS MEMBERS
WELD FIRST FIVE INTERSECTIONS
THEN EVERY SECOND INTERSECTION
ADDITIONAL WELDS ARE PERMITTED AS REQUIRED

BOTTOM VIEW (03) MESH





TOP VIEW

(01) LID ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2685C.
- 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
- DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 18F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-8736	0.75 X 0.035 SOR TUBE
	84012-01	01	LID ASSEMBLY			
LIST OF MATERIALS						

APPROVALS		DATE		AERO DESIGN LTD.	
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CHECKED: E. BURDON					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				EUROCOPTER AS350 & AS353 SERIES	
DECIMALS		ANGLES		QUICK RELEASE CARGO BASKET	
X.XXX ±0.010		±1/2°		LID ASSEMBLY (EXTRA LARGE)	
X.XX ±0.03					
X.X ±0.1					
SCALE 1: 4			DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1			A1	94012	1



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EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID ASSEMBLY (EXTRA LARGE)

Work Order: 2016-154Date Opened: Nov 2016Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	94012	94012-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
Step 5		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
Step 6				<i>Weld Frame Assembly</i>		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 8				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	<u>16038</u>
Step 9				<i>Weld Mesh</i>		
	. A/R			Welding Rod	ER70S-6 MIG Wire	<u>15059</u>

Work Order: 2016-154Date Opened: Nov 2016Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	1	84262	84262-01	Upper Handle Bracket Assembly		2016-147
	4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	2		36275-02	Support	304 Stainless, 5/16" Rod	
	A/R			Welding Rod	ER308L TIG Rod	14028
	2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	A/R			Welding Rod	ER308L TIG Rod	14028
	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2014-81
	A/R			Welding Rod	ER70S-2 TIG Rod	14033
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				Powder Coating		16081